

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005344**Date Inspected:** 02-Feb-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** MaKhmud Ashadi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower saddle and deviation saddle**Summary of Items Observed:**

Steel Structure Welding Shop:

W2E2 West Deviation Saddle Casting and Steel Structure Joint Section: Caltrans Quality Assurance Inspector (QAI) representative observed Japan Steel Works (JSW) welders performed FCAW welding processes on rib plate weld E2Y-17U-1 and E2Y-17U-2 of W2E2 west deviation saddle and steel portions. Those welds are connecting to casting and steel structure. The proper filler metal used for FCAW is Hoballoy TM-95K2, 1.6 diameter with 100% C02. The entire structure has been preheated to minimum 160C prior welding. The FCAW welding process and parameters have been monitored and recorded by CWI inspector Mr. MaKhmud Ashadi. Based on Caltrans observations, the FCAW welding operation appeared to be in general compliance with requirements of AWS D1.5 2002 and Caltrans contract documents.

W2E3 West Deviation Saddle Steel Structure: Caltrans QAI representative observed a welder perform FCAW processes on a rib plate weld #E3Y-11V-1 of W2E3 west deviation saddle. The filler metal and shield gas used for FCAW is Hoballoy wire TM-95K2, 1.6 diameter with 100% C02. The entire welding zone has been preheated to minimum 110C prior welding. The FCAW welding process and parameters have been monitored and recorded by CWI inspector Mr. MaKhmud Ashadi. Based on Caltrans QA observations, the FCAW welding operation appeared to be in general compliance with requirements of AWS D1.5 2002 and Caltrans contract documents.

**Summary of Conversations:**

As noted within the report above.

**Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

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## WELDING INSPECTION REPORT

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remedial efforts please contact Nina Choy, who represents the Office of Structural Materials for your project.

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| <b>Inspected By:</b> | Pau, Wai | Quality Assurance Inspector |
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| <b>Reviewed By:</b> | Lanz, Joe | QA Reviewer |
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